

# Work Order ID 64092

Wednesday, November 24, 2010 8:51:30 AM



Page 1

Item ID: D2803-041

Accept



Setup Start



Revisor ID:

Stop



Item Name: Bracket Assembly

Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-1 into arm as per Dwg D2803

EP 10/12/20 (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/12/20

(46)

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

9:30

OVEN TEMPERATURE:

300° FINISH TIME:

10:00

6 10/12-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64092**

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Item ID: D2803-041

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Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC3- Inspect Part Finish

0.00

JL

10/12/21

QC

Memo

0.00

X6 0

Quality Control

140



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Press D2809 into arm as per Dwg D2803

ES 11/01/04 (6)

150



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2803.

ES 11/01/04 (6)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




# Work Order ID 64092

Wednesday, November 24, 2010 8:51:30 AM

Page 3

Item ID:	D2803-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Assembly					
Start Date:	11/24/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	11/30/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		<i>Set 11/01/04</i>		<i>(X6)</i> <i>-011</i>			
170  Packaging Packaging	Identify as per dwg & Stock Location: <i>149</i>  Memo	0.00  0.00				<i>11/1/04 SP (6x)</i>			
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				<i>CA</i> <i>11/01/05</i> <i>YMF</i> <i>11-01-04</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, November 24, 2010 8:51:34 AM

Page 1

Work Order ID: 64092

Parent Item: D2803-041

Parent Item Name: Bracket Assembly



Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-1  Bracket		Manufactured	No			100	Each	2.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST148		2							
					46610	2							
D2805-1  Stop		Manufactured	No			100	Each	22.0000	1	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST024		22							
				58527 ✓		10							
				62247		12							
NAS1515H3  Washer		Purchased	No			100	Each	174.0000	4	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		174							
				111268		4							
				115675		70							
				115935		100							

B 64458



SD 10/12/17

6

M-L 10/12/17

EP 10/12/20

6x

EP 11/01/04

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Wednesday, November 24, 2010 8:51:34 AM

Page 2

Work Order ID: 64092

Parent Item: D2803-041

Parent Item Name: Bracket Assembly

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

AN3C16A

Purchased

No

150

Each

97.0000

2

8



Bolt



*ES 11/01/04*

Location

Loc Qty

Loc Code

ST352

97

111193

6

111425

41

115835

50

*12*

D2809

Manufactured

No

150

Each

37.0000

1

4



Bushing



*ES 11/01/04*

Location

Loc Qty

Loc Code

ST025

37

34035

12

46438

1

47733

24

*6*

MS21043-3

Purchased

No

150

Each

2,191.000

2

8



Nut



*ES 11/01/04*

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2115

112314

2115

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<u>64092</u>
<b>Description:</b> Bracket		<b>Part Number:</b>	D2803-1
<b>Inspection Dwg:</b> D2803 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000					
Ø0.191	+0.005/-0.000					
Ø0.507	+0.000/-0.001					
13.558	+/-0.010					
Ø0.507	+0.000/-0.001					
12.411	+/-0.010					
2.654	+0.000/-0.001					
0.437	+0.000/-0.001					
1.420	+/-0.001					
6.933	+/-0.010					
0.250	+/-0.010					
0.875	+0.000/-0.001					
0.250	+0.000/-0.005					
0.125	+/-0.010					
0.125	+/-0.010					
0.125	+/-0.010					
0.125	+/-0.010					
0.500	+/-0.010					
0.562	+/-0.010					
0.188	+/-0.010					

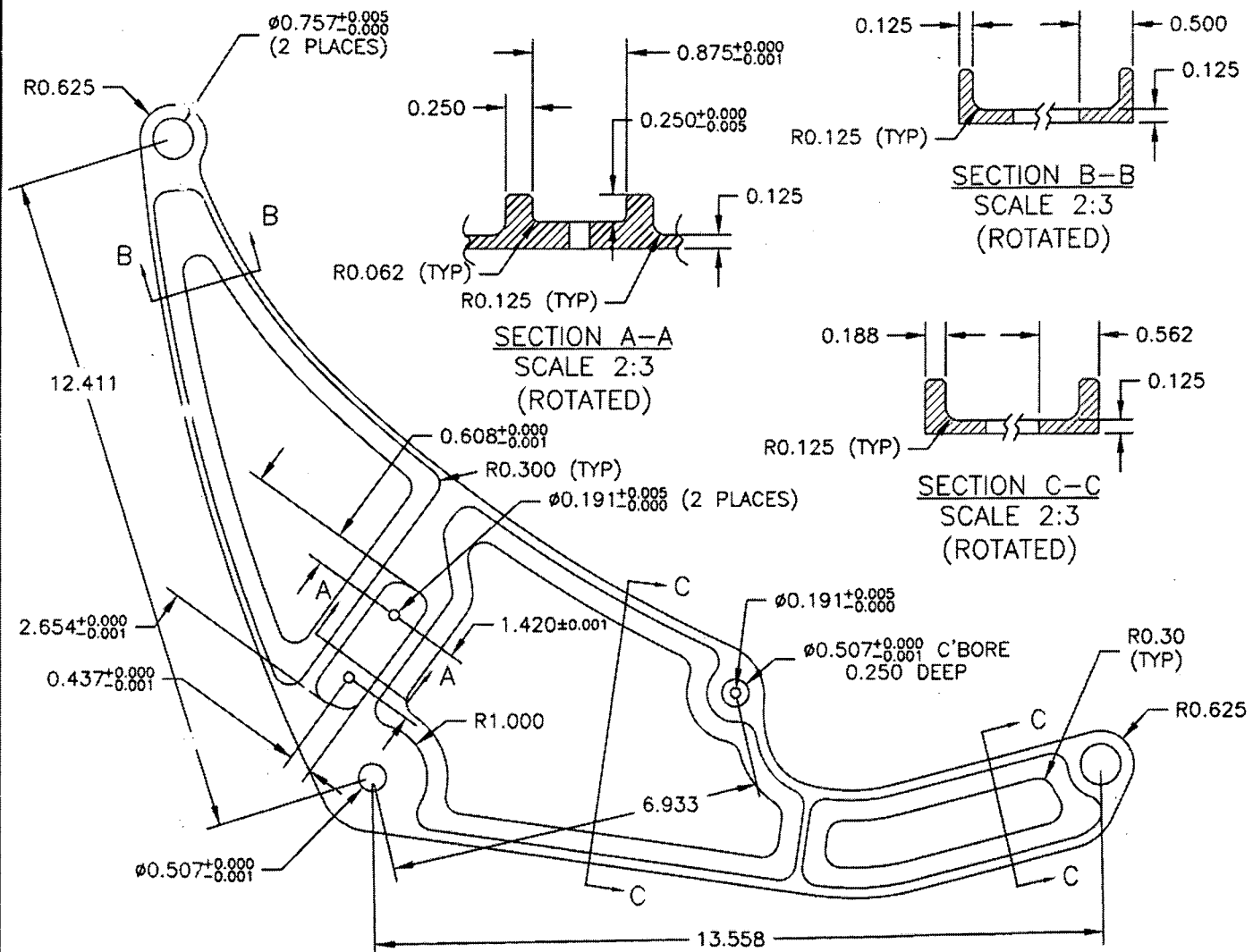
<b>Measured by:</b>		<b>Audited by:</b>		<b>Prototype Approval:</b>	N/A
<b>Date:</b>		<b>Date:</b>		<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	07.07.18	12.625 dimension removed	KJ/JLM	<u>BE</u>

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11 *[Signature]*SHOP COPY  
RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *U41092***D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

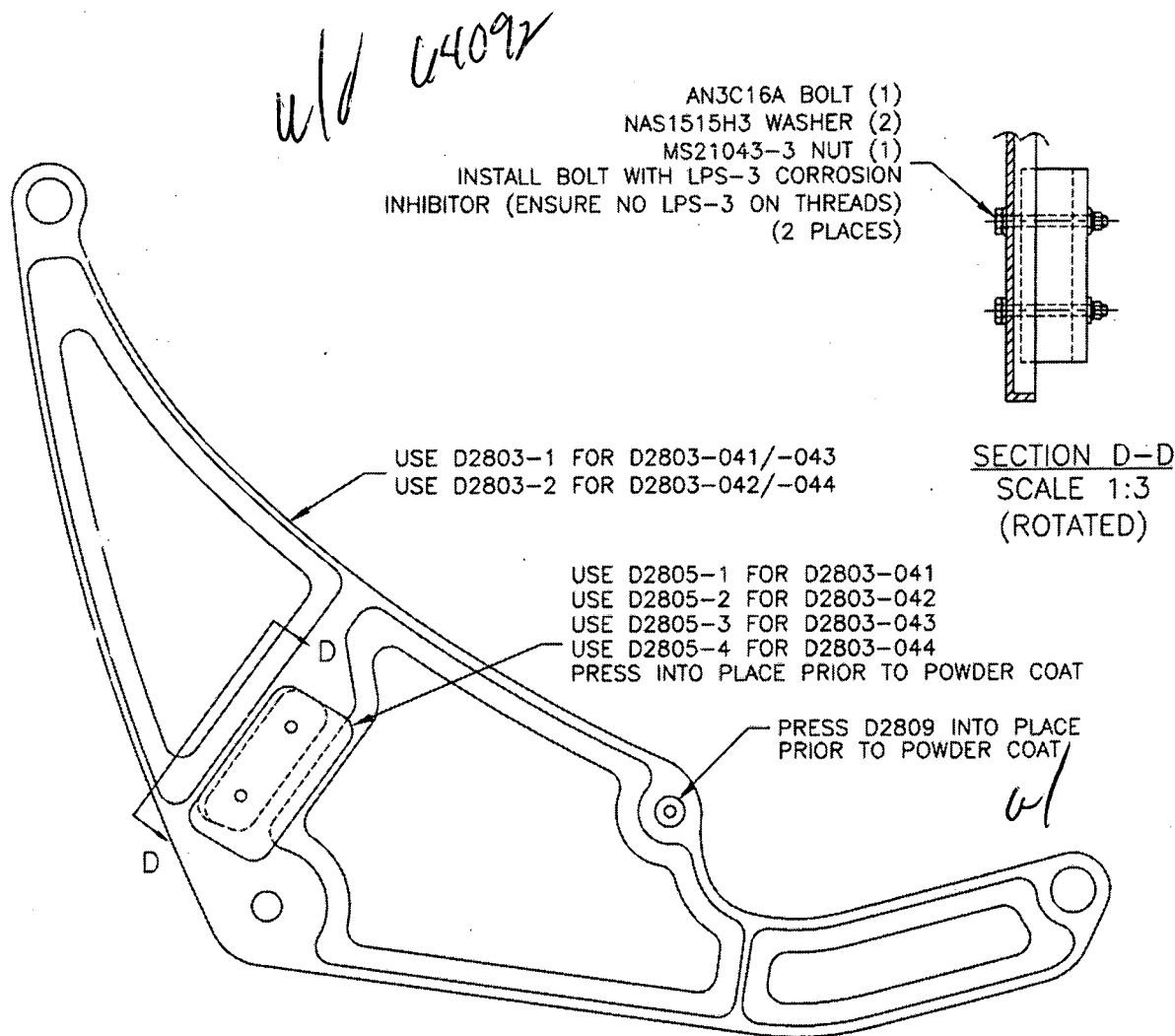
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. 3
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	SHEET 2 OF 2
				D2803	
DATE	04.11.22			TITLE	SCALE
				STA 84 BRACKET	1:3



RELEASED

05-03.11

**D2803-041/-043 BRACKET ASS'Y (SHOWN).**  
**D2803-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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